

Date: Tuesday, 3/11/2008 7:57:10 AM  
User: Kim Johnston

## Process Sheet

15

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : AVIONICS RISER CONSOLE  
Job Number : 37738  
Estimate Number : 10259  
P.O. Number : Part Number : D212722011  
This Issue : 3/11/2008 S.O. No. : Drawing Number : D3363 REV C  
Print Rev. : NC Project Number : N/A  
First Issue : 11 Type : SMALL /MED FAB Drawing Revision : C  
Previous Run : 37045 Material :  
Written By : Due Date : 4/7/2008 Qty: 5 Um: Each  
Checked & Approved By : JWS 0311  
Comment : Est Rev: B 05-04-11 Now made at Dart KJ/JLM  
Est Rev: C 07-06-09 Holes now Transfer drilled JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 DC DOCUMENT CONTROL



JWS 08.5.22 +5



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D212-722-011 CHG002

FF 08/05/23

2.0 M6063T5A0750W063 Angle 6063T5X.75X.75X.063



M107711  
M107435 X 30 ft.



Comment: Qty.: 7.2450 f(s)/Unit Total: 28.9800 f(s) 65.205

Material: 6063-T52 Aluminum angle 3/4" x 3/4" x 0.063" wall(M6063T5A0.750W.063)

Batch: M107435 X 3245 ft.

FF 08-04-10 (9)

3.0 M6063T5C75X75W125 6063 CHANNEL 75X.75X.125



Comment: Qty.: 0.8290 f(s)/Unit Total: 3.3160 f(s) 7.461

Material: 6063-T52 Aluminum channel 3/4" x 3/4" x 0.125" wall(M6063T5C.75x.75W.125)

Batch: M107435

FF 08-04-10 (9)

4.0 D33631 CONSOLE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch  
1 D3363-1 Console (Bent) 338263

FF 08-04-24 (9)

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

1-Cut (2) D3360-1, (2) D3360-3 & (2) D3360-5 to length as per Dwg D3360 Material: 6063-T52 Aluminum  
angle 3/4" x 3/4" x 0.063" wall

FF 08-04-10 (9)

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AVIONICS RISER CONSOLE

Job Number: 37738

Part Number: D212722011

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Cut (1) D3361-1 to length as per Dwg D3361 Material: 6063-T52 Aluminum channel 3/4" x 3/4" x 0.125" wall

3-Deburr D3360-1/-3/-5 &amp; D3361-1

4-Transfer drill and C'Sink D3360-1/-3/-5 &amp; D3361-1 from D3363-1 as per D3363. Do not rivet together

5-Deburr all parts

FF 08-04-24 (9)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BR 08-04-24 (9)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FF 08-04-24 (9)

8.0

PR351

DZUS FASTENER RAIL



Comment: Qty.: 0.3333 f(s)/Unit Total : 1.3332 f(s)

Material: Dzus Fastener Rail

(PR35-1 or PR3-1/2-1)

Batch: 117763 x 17 / m107913 x 1

FF 08-04-24 (9)

9.0

MS20426AD45

Rivet



Comment: Qty.: 44.0000 Each(s)/Unit Total : 176.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

44 MS20426AD4-5

Rivet

M 3459

FF 08-04-24 (9)

10.0

MS20426AD46

Rivet



Comment: Qty.: 9.0000 Each(s)/Unit Total : 36.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

9 MS20426AD4-6

Rivet

M 105144

FF 08-04-24 (9)

11.0

SMALL FAB 1

SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

1-Cut (2) D3362-1 to length as per Dwg D3362 Material: Dzus Fastener Rail

FF 08-04-24 (9)



Kim Johnston

# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AVIONICS RISER CONSOLE

Job Number: 37738

Part Number: D212722011

Job Number:



Seq. #:

Machine Or Operation:

Description :

\*\*\*Mount Dzus Rails to DT8957 (Radio) and transfer drill into console.\*\*\*

2-Rivet D3360-1/3/5 & D3361-1 & D3362-1 as per Dwg D3363  
Identify as D3363-041

FF 08-04-29

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/05/15 (A)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

14.0

PFSC3538A

Dzus 1/4 turn fastener



Comment: Qty.: 8.0000 Each(s)/Unit Total: 32.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description

Batch

8 PFSC35-38A

Dzus Fastener

M107014 x24

M19567 x8

1 d3363-041

Console Ass

37738 AS

AS 08/05/15 (A)

15.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

08/05/23 x5

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D212-722-011

8/6/03

(5x)

39

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/26

Job Completion



MF 08-05-23